



Dart Aerospace Ltd.
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RBE117-12010W61
Job Sheet 185535



Part No: RBE117-12010W61

Job Qty: 1 ea 2

Part Name: Wrench Set, Torque Multiplier



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/29/18

Job Tracking No:

Due Date: 12/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-12010W61 Rev.1 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/27/18	12/27/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	1 pcs	12/27/18	12/27/18	0.00	1.00	Small Fab-3		M. L. L.
120	QC	1 pcs	12/27/18	12/27/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	12/27/18	12/27/18	0.00	0.00	Packaging3-1		7/10 9-89
140	QC21-FG	1 Ea	12/27/18	12/27/18	0.00	0.00	QC21		21

Part Op 110 - 1-Assemble as per DWG.

Descriptions: 130 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE117-12010W61-1	Gear Wrench	1 Ea (1 ea)	90-Start up Operation	IN 5136271
RBE117-12010W61-3	Torque Multiplier	1 Ea (1 ea)	90-Start up Operation	IX 5131166
				IX 6136905

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBE117-12010W61-1	1	0	0
	RBE117-12010W61-3	1	0	0

Part Specifications

Specifications could not be found.



Container No: S137169



Part: RBE117-12010W61

Job No: 185535

Serial No/Batch: S137169

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 12/12/18

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CANADA
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www.dartaerospace.com

Plex 10/29/18 2:09 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

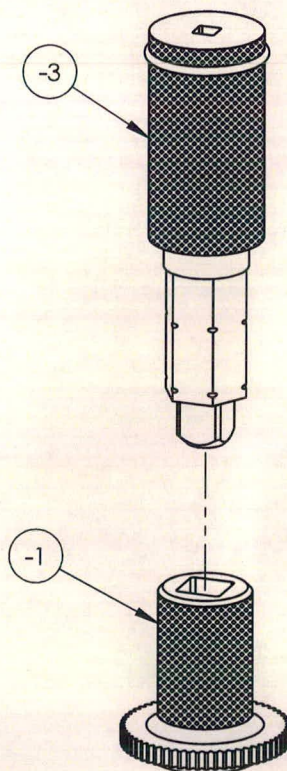
QA Closed: _____ Date: _____

Work Order update only ☐

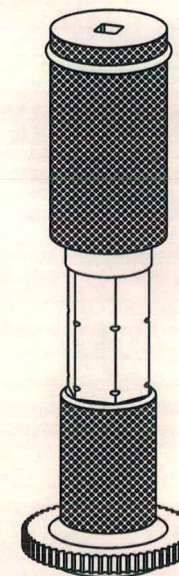
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
Root Cause				FAULT CATEGORY																																																											
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																								OTHER :																																							

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
1		RELEASED FOR PRODUCTION.		4/25/2016	RJC	JAG



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WORK ORDER
NO. 185535 MLC
18-10-29



- NOTES:
1. REF. EUROCOPTER T/N: 117-12010W61.
2. PART OF KIT RBE117-12010W62.

DART AEROSPACE	
TITLE WRENCH SET - TORQUE MULTIPLIER	
DWG NO. RBE117-12010W61	REV 1
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:4	DATE 2/23/2016 SHEET 1 OF 2

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	GEAR WRENCH	4140/4142		2
		B/O	-3	1	TORQUE MULTIPLIER		(MOTION INDUSTRIES; TOHNICHI #DECA900N)	1



CERTIFICATE OF CALIBRATION

校正証明書

NAME:	TORQUE ATTACHMENT	DATE FIRST USED:	/ /
MODEL:	DECA900N	SERIAL NO.:	802358J
MAX CAPACITY:	900	ACCURACY $\pm$ (%):	5
UNIT:	N·m	TEMPERATURE (°C):	23
DATE OF CALIBRATION:	11/10/2018	INSPECTOR:	H. KAWAMATA
(Day/Month/Year)			

INSPECTION SCALE

180
300
600
900

ACTUAL READING

CLOCKWISE

182
299
578
871

COUNTER CLOCKWISE

上記製品は、国家標準にトレースされた参照標準を基準とした標準器を用い、当社の作業標準に従って校正が行われ、校正作業における検査または試験結果が製品仕様を満足していることを証明します。
WE CERTIFY THAT PRODUCT IDENTIFIED ABOVE WAS CALIBRATED USING REFERENCE STANDARD THAT IS TRACEABLE TO THE NATIONAL STANDARDS SPECIFICATIONS AND ACCORDING TO TOHNICHI STANDARDS.
WE HAVE VERIFIED THAT THESE TEST RESULTS COMPLY WITH PRODUCT SPECIFICATIONS.



CERTIFICATE OF CALIBRATION

校正証明書

NAME: TORQUE ATTACHMENT
MODEL: DECA900N
MAX CAPACITY: 900
UNIT: N·m
DATE OF CALIBRATION: 12/11/2018
(Day/Month/Year)

DATE FIRST USED: / /
SERIAL NO.: 802644J
ACCURACY± (%): 5
TEMPERATURE (°C): 23
INSPECTOR: H. KAWAMATA

INSPECTION SCALE

180
300
600
900

ACTUAL READING

CLOCKWISE

177
297
586
874

COUNTER CLOCKWISE

上記製品は、国家標準にトレースされた参照標準を基準とした標準器を用い、当社の作業標準に従って校正が行われ、校正作業における検査または試験結果が製品仕様を満足していることを証明します。
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